

# Work Order ID 53221

October 27, 2009 10:20:58 AM



Page 1

Item ID: D2438

Accept



Setup Start



Revision ID: C

Stop



Item Name: Clamp

Start Date: 10/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 09/10/27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2438	Rev C								

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10047 ☐ Laser cut as per Dwg D2438 ☐ Material release note is required

CL 09/10/27 (100)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 9/11/09 (100)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

(6.786" center to center)

=> Saludo

counte  
(H.02) 4  
QSPOL9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Sign & initial all entries

# Work Order ID 53221

October 27, 2009 10:20:58 AM



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Item ID: D2438

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Setup Start



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Item Name: Clamp

Start Date: 10/27/09 Start Qty: 100.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Tumble & Deburr any rough edges								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150  Packaging	Identify as per dwg & Stock Location: <u>456</u>	0.00							
Packaging	Memo	0.00							

B 9-11-23

(102)

2750211/23

coate

(102) f

9/11/24

(102) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53221

October 27, 2009 10:20:58 AM



Page 3

Item ID: D2438

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Setup Start



Revision ID: C

Stop



Item Name: Clamp

Start Date: 10/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/25 98

Pl 09-11-24  
(100)

# Picklist Print

October 27, 2009 10:20:57 AM

Page 1

Work Order ID: 53221



Parent Item: D2438RevC



Parent Item Name: Clamp

Start Date: 10/27/09

Required Date: 11/20/09

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2438BRevC		Purchased	No			110	Each	0.0000	100.0000			
Clamp												

10/27/09 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

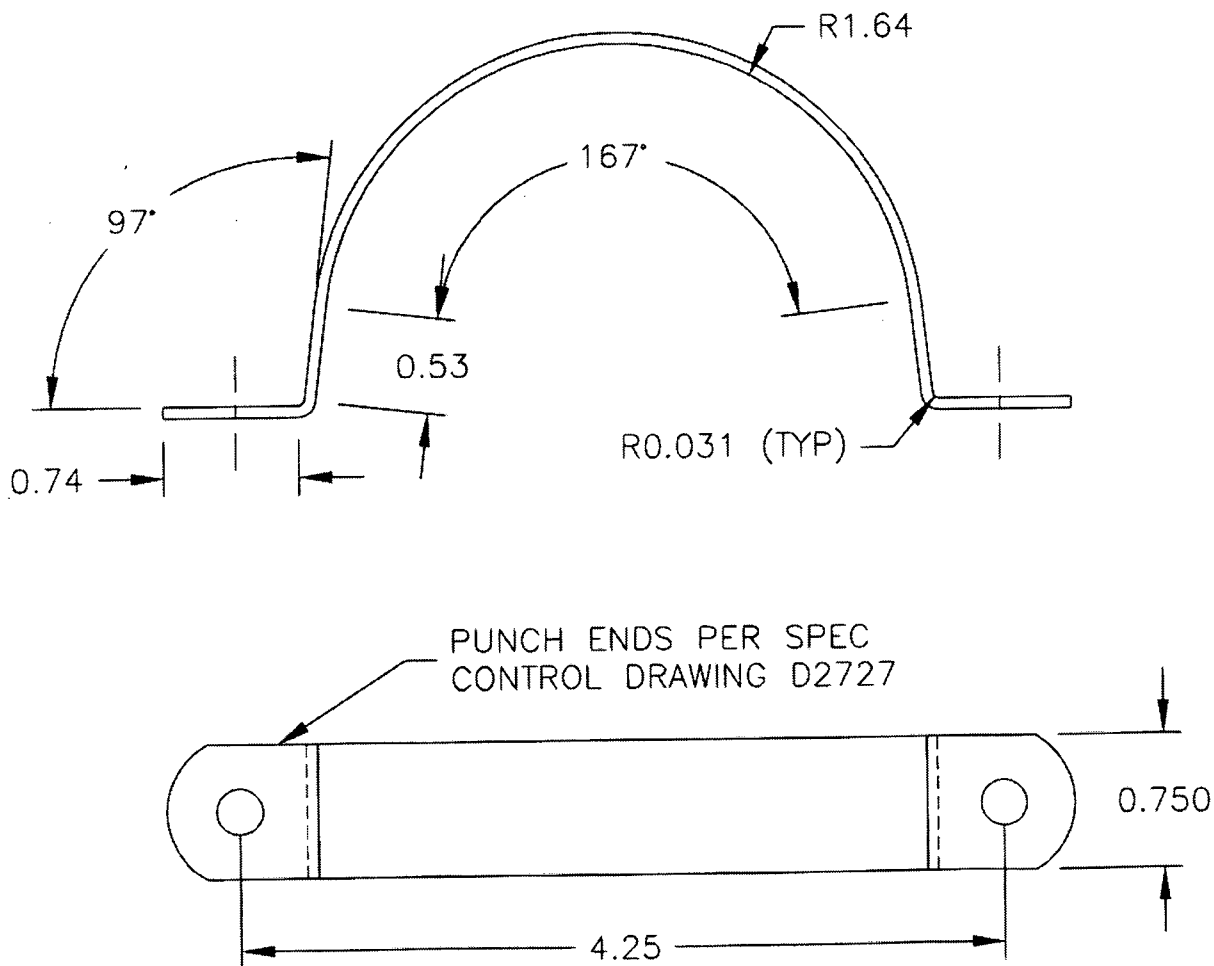
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WJS</i>	APPROVED <i>WJS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
98.06.17 KE



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK  
MINIMUM REQUIREMENT IS ANNEALED CONDITION

# 20 06 06  
P 00 00 07





180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDEUR / SOLD TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7




# BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2009/11/18	0428248

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299		J0206784	P010647	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
100	D2438B	CLAMP CUT&FORMED CERTIFICATE OF CONFORMANCE REQ		
MFG. JOB # <u>J0206784-01</u> QTY <u>100</u>				
				
S sluho				

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

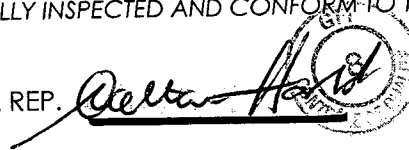
**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	22	OUR JOB NO	J0206784	SHIPPING MEMO	0428248	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
---	100 PCS	PO10647	D2438B	C	CLAMP	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		TW METALS / ALLEGHENY LUDLUM		828977		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER J0206784-01 (100 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **18 NOVEMBER 2009**

G.F.I. Q.C. REP. 

DP12-001 REV 0 Bombardier Certificate of Compliance  
TW Metals District Procedure

Revision 0

Revision Date 04-03-00

Superseding Initial

Page 1 of 1

## CERTIFICATE OF COMPLIANCE

## FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law Title 18 chapter 47

## CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications

## MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard

CUSTOMER NAME GFI  
PURCHASE ORDER No 0075846  
ITEM No 0001 SHIPPER INVOICE No 03251327  
MATERIAL 304-5/5 Sheet SPECIFICATION AMS 2248F  
MANUFACTURING MILL ATI Allegheny Ludlum  
SIZE 0625 HEAT / LOT No 828977  
PART No TS06348X964A QUANTITY 2EA.  
TEST DEPARTMENT CLERK Amy Davis

## AUTHORITY

Joe Schab  
Director of Quality Assurance

07/16/20  
S

This document is maintained as a Controlled Document only in the TW Metals computer system. Once printed, this document immediately becomes Uncontrolled and is subject to change at any time and without notice.

NOTICE OF SHIPMENT/  
PACKING LIST

## CERTIFICATE OF TEST

AL 8180-3 000

CUST. ID, QTY, NO. & DATE		CUST. CODE		ACCEPTING MFG.		SHIPPER NO.		PROJECT CODE		BILL ORDER NUMBER		DATE SHIPPED	
01014169		04/02/09 110977		VANDERGRIFF, PA.		423467		13020102060000		30-049-021		06/22/09	
FORMS DISTRIBUTION		REPEAT ORDER		DO DATE		OCTO CONTRACT		MATERIAL		SHIPMENT LOCATION		INVOICE	
1		82037-4		26				11124		TRANSFERRED TO		PR 657053	
		PRIME SEC.		DSO DSO		584							

## GRADE AND SPECIFICATIONS

CARRIER - CLAY TRANSPORT, INC.

ALLEGHENY STAINLESS STEEL TYPE 304 SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UFM 304L/304/302 LCS) (AMS 2248P) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-08A) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (10/22/08 EXCEPT OPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (PWA 300 REV BH) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

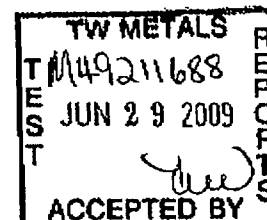
AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUM'S KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998, SECTION 252.225-7014
2. - FOREIGN MELT AND ROLLED IN THE UNITED STATES



PAGE 02 - CONTINUED ON PAGE 03

06/22/09 09:48:07

**DISCLAIMER:** This document is a summary of the information provided by the customer. It is not intended to be a substitute for the original document. The user is responsible for verifying the accuracy of the information provided. The user is also responsible for ensuring that the information is used in accordance with the applicable laws and regulations.

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**NOTES:** The user is responsible for ensuring that the information is used in accordance with the applicable laws and regulations. The user is also responsible for ensuring that the information is used in accordance with the applicable laws and regulations.

## AL 105 2020

The above is a true copy of what was said by the witness and the  
 contents of the same are true and correct and the witness is  
 sworn to the truth of the same.  
 T. J. McNeil  
 T. J. McNeil  
 T. J. McNeil

So 14/20

TW METALS  
TEST  
M49211688  
JUN 29 2009  
ACCEPTED BY



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO10647**

Purchase Order Date 10/27/09

PO Print Date 10/27/09

Page Number 1 of 1

**Order From :**

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

**FAKED**

<b>Contact Name</b>		<b>Buyer</b>	Chantal Lavoie
<b>Vendor Phone</b>	514 630 4877	<b>Requisition Nbr</b>	
<b>Vendor Fax</b>	514 630 4849	<b>Tax Resale Nbr</b>	10127-2607
<b>Vendor Account Nbr</b>		<b>Terms</b>	Net 30
		<b>Currency</b>	CAD
		<b>FOB</b>	

**Ship To :** DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2438B C	Clamp	11/20/09 Yes	100.00 Each	Purolator ground	\$10.0000	\$1,000.00

**Special Inst:** AS PER DWG D2438 REV.C  
B53221  
FORMED & BEND AS PER DWG

**PO Total:** \$1,000.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 10/27/09

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable